

Work Order ID 80090

80090

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February-09-12 4:29:34 PM

Item ID: D2970-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate

Start Date: 09/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.C.S

Date: 12/02/10

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2970

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2970 Dwg Rev: A Prog Rev: A 2-

1010-040

Deburr if necessary

B12-3-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-5

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5763106

Ⓢ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

Debur and form on brake using DT8178 and DT8261 as per Dwg D2970

SB 12/03/07

5

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/2/07

150

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

START TIME: 4h05 320°F OVEN TEMPERATURE:

4h35 FINISH TIME:

m18 489

5

5

12/03/08

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

5 & 10 12/03/09

5 M/K 12/03/09

MLJ 12/03/09

12-03-9

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Picklist Print

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J

Work Order ID: 80090

80090

Parent Item: D2970-1

D2970-1

Parent Item Name: Wearplate

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B01.06.07 Added Material and Tool number SM/EC
IPP Rev: C Now on Waterjet 07-06-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			110	sf	112.2000	0.365	2.305263			

M1010S20GA

**

B12-3-5

1010/1025 SHEET

Location

Loc Qty

Loc Code

MAT019

112.2

111410

45.2

116791

67

111410

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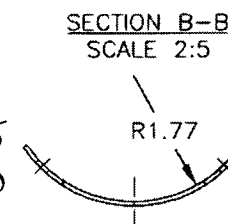
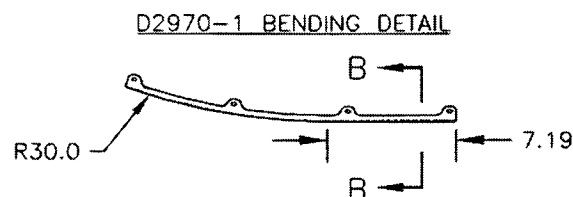
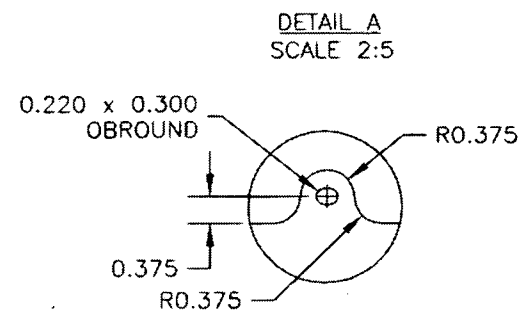
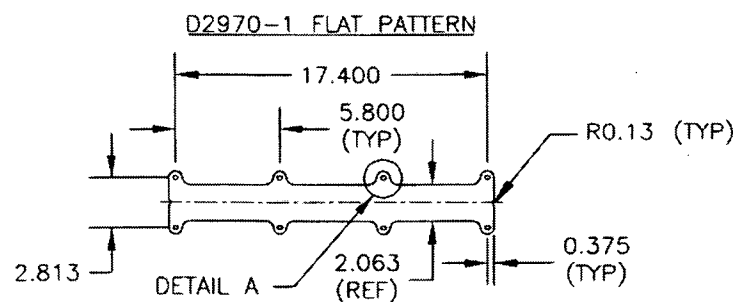
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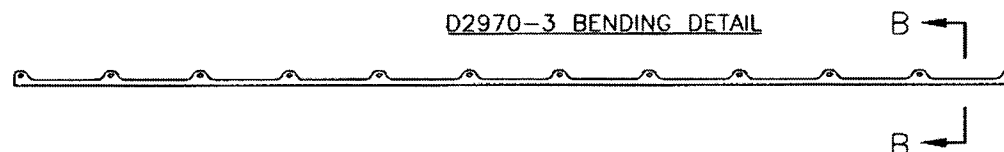
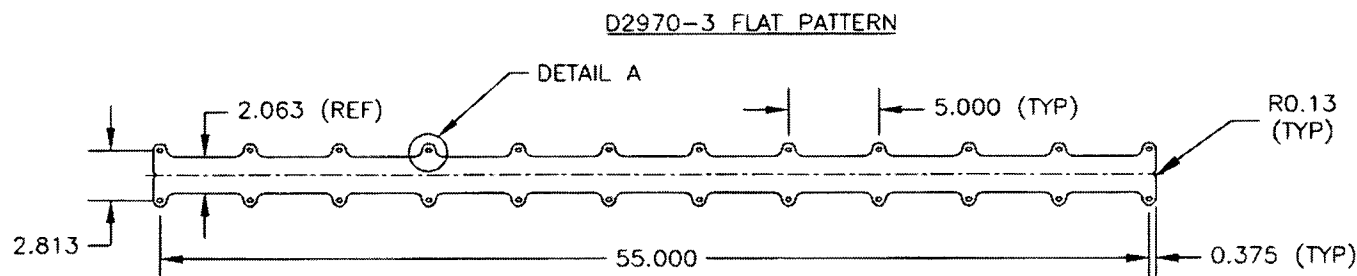
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
RF	RF	BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2970
DATE	TITLE	REV. A
00.03.10	WEARPLATE	SHEET 1 OF 1
A	00.03.10	NEW ISSUE
		SCALE 1:10



80090 MCV
12/02/10



BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

RELEASED
00.05.11

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